

Work Order ID 164706***164706***

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Friday, July 28, 2017 8:24:18 AM

Item ID: D4956-35 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Aft
Start Date: 8/31/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 9/7/2017 Req'd Qty: 8.00 ***8*** Customer:

Reference:

Approvals: Process Plan:  Date: JUL 28 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4956	A

100

0.10

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.78



02/17/28/12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.08



02/17/28/12

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.16				<u>878</u>			DAS 38 9-89 AUG 14 2017
130 *130* Brake NC Brake NC	Form as per dwg Memo	0.21 0.83				<u>878</u> 8		<u>17-8-15</u>	DAS 19 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.16				<u>878</u> 8		<u>17-08-15</u>	

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
HandFinish	Memo	0.32							
Hand Finishing	1- After finish, coat entire top (concave) surface as per note 2 dwg D4956. TEXTURED COATING B#: <u>138220</u>					8		17-08-22	
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.08							
Quality Control						8		AUG 25 2017	
170	Identify as per dwg & Stock Location: <u>FP002</u>	0.00							
170									
Packaging	Memo	0.08							
Packaging	LOCATION : FP002					(X8)	Ø	201708/25	BEB

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Required Date: 9/7/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.80							
Quality Control									



AUG 25 2017

DAS
21
9-88

Picklist Print

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Work Order ID: 164706

164706

Parent Item: D4956-35

D4956-35

Parent Item Name: Wearplate Aft

Start Date: 8/31/2017

Required Date: 9/7/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

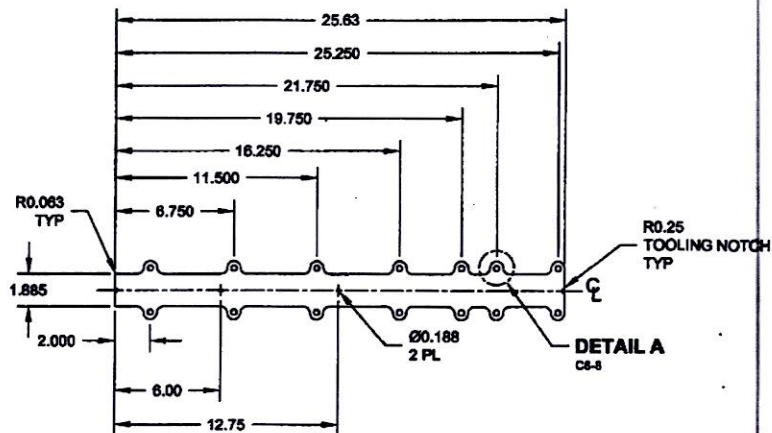
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	42.4800	0.7	5.894737			
M304S20GA									**				
304/316 .040 Sheet													

02/17/08/12

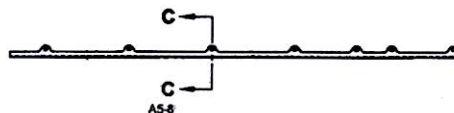
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	42.48	
m137513	12.5	
m137762	8.7	
m137980	21.28	

4.8
5

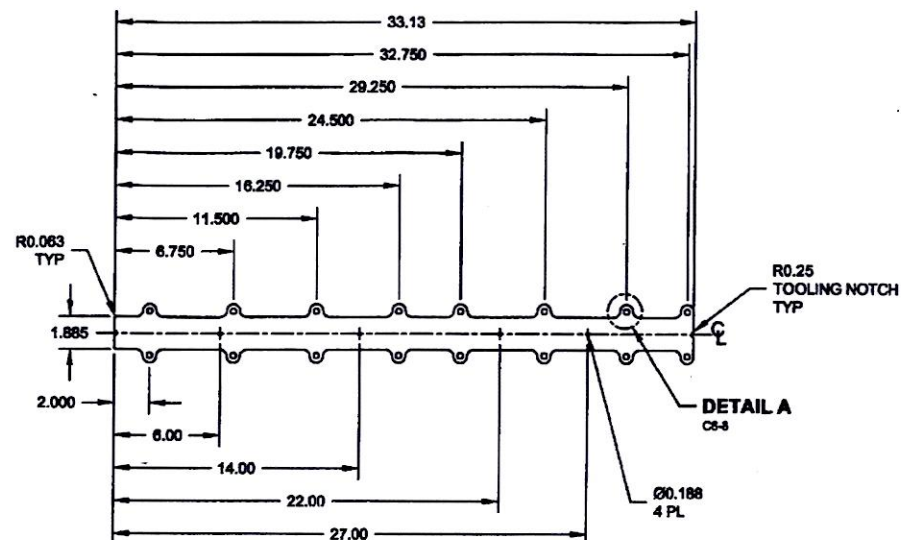
138175



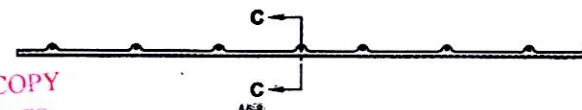
D4956-35F FLAT PATTERN



D4956-35 WEARSHOE
(MAKE FROM D4956-35F)



D4956-37F FLAT PATTERN



D4956-37 WEARSHOE
(MAKE FROM D4956-37F)

NOTES

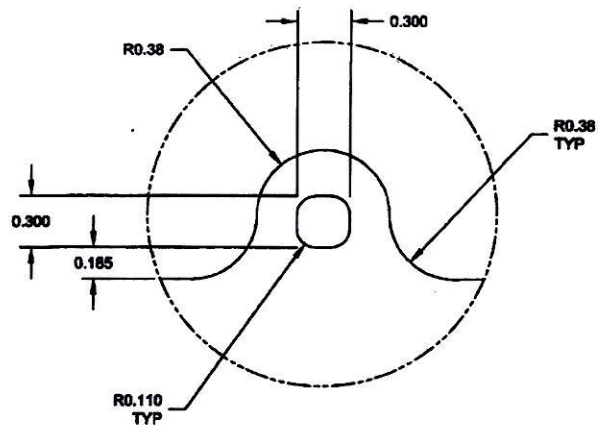
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4956-35 = 0.60 lbs; D4956-37 = 0.76 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164706

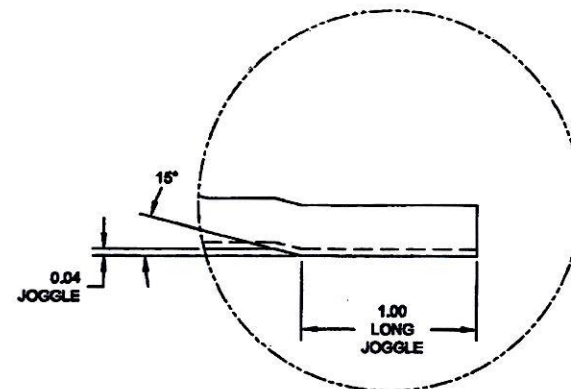
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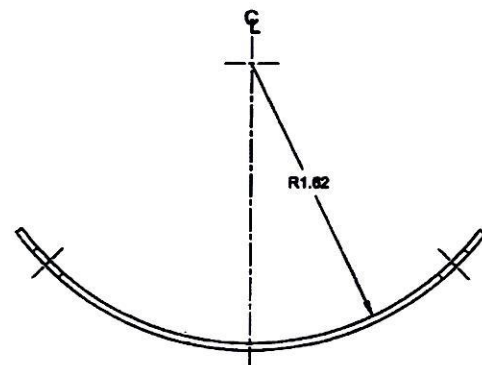
RELEASED
2014-04-17



DETAIL A C8-1 C4-1
C8-2
C8-3 C1-3
C8-4
C8-6 C2-6
C8-8 C2-8
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2
B5-3 B1-3
B2-4
B4-7 B1-7



SECTION C-C B7-1 B3-1
B5-2
B7-3 B3-3
B6-4
B7-5 B3-5
B7-6 B3-6
B7-7 B3-7

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